

Date: Wednesday, 9/12/2007 12:13:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 34608	
Estimate Number : 12546	
P.O. Number :	Part Number : D3256041
This Issue : 9/12/2007 S.O. No. :	Drawing Number : D3256 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33830	Material :
Written By :	Due Date : 10/10/2007 Qty: 6 Um: Each
Checked & Approved By : <u>07/09/12</u>	
Comment : Est Rev: A New Issue 06-10-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.9870 sf(s)/Unit Total : 3.9480 sf(s)
 304/316 .032 Sheet
 Batch: 105262 HB 07-09-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3256
 Dwg Rev: B HB 07-09-18
 Prog Rev: B
 2-Deburr if necessary HB 07-09-18

⑦

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 09/09/18 ⑦ counter

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE Form using D3256-1T2

07/11/12

Scrap parts
per ECN 1052

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:41 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34608

Part Number: D3256041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D32563

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: _____

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install D3256-3 gasket using 3M Scotch-grip adhesive as per Dwg D3256

A/R 1300/1300L 3M Adhesive Batch: _____

2-AFTER CURING,transfer holes from D3256-1 into D3256-3.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. O. F. 11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

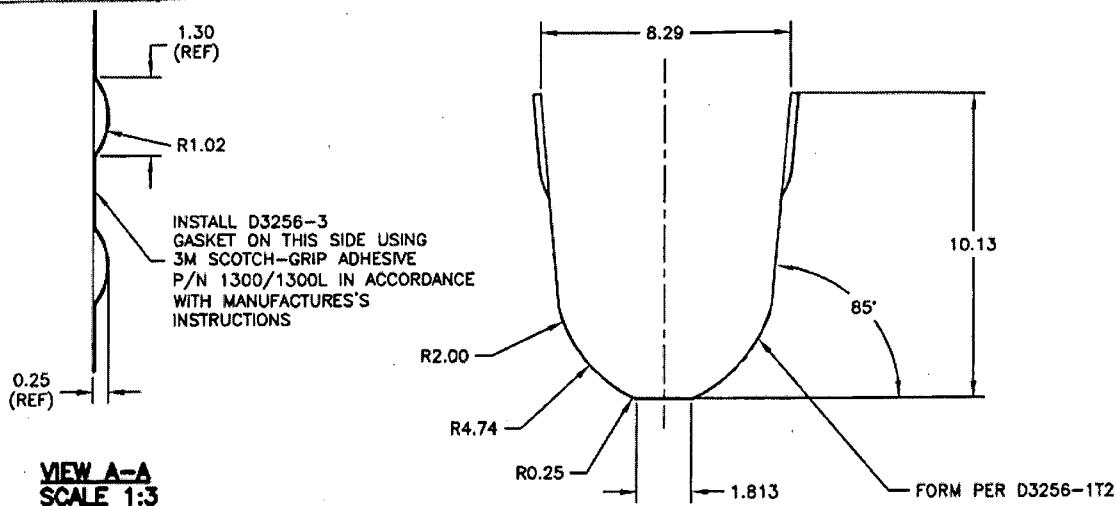
NOTE: Date & initial all entries



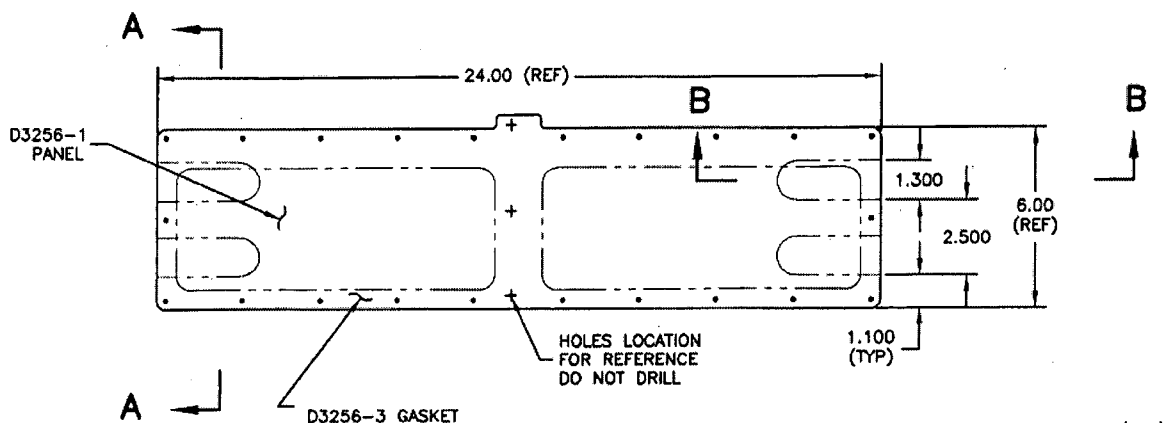
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 1 OF 3
DATE 05.06.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:6
A	04.01.27	NEW ISSUE	
B	05.06.27	D3256-3 DIM 1.30 WAS 0.65	

RELEASED

05.06.30 *[Signature]*



VIEW A-A
SCALE 1:3



VIEW B-B
SCALE 1:3

D3256-041 ACCESS PANEL ASSEMBLY

1) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

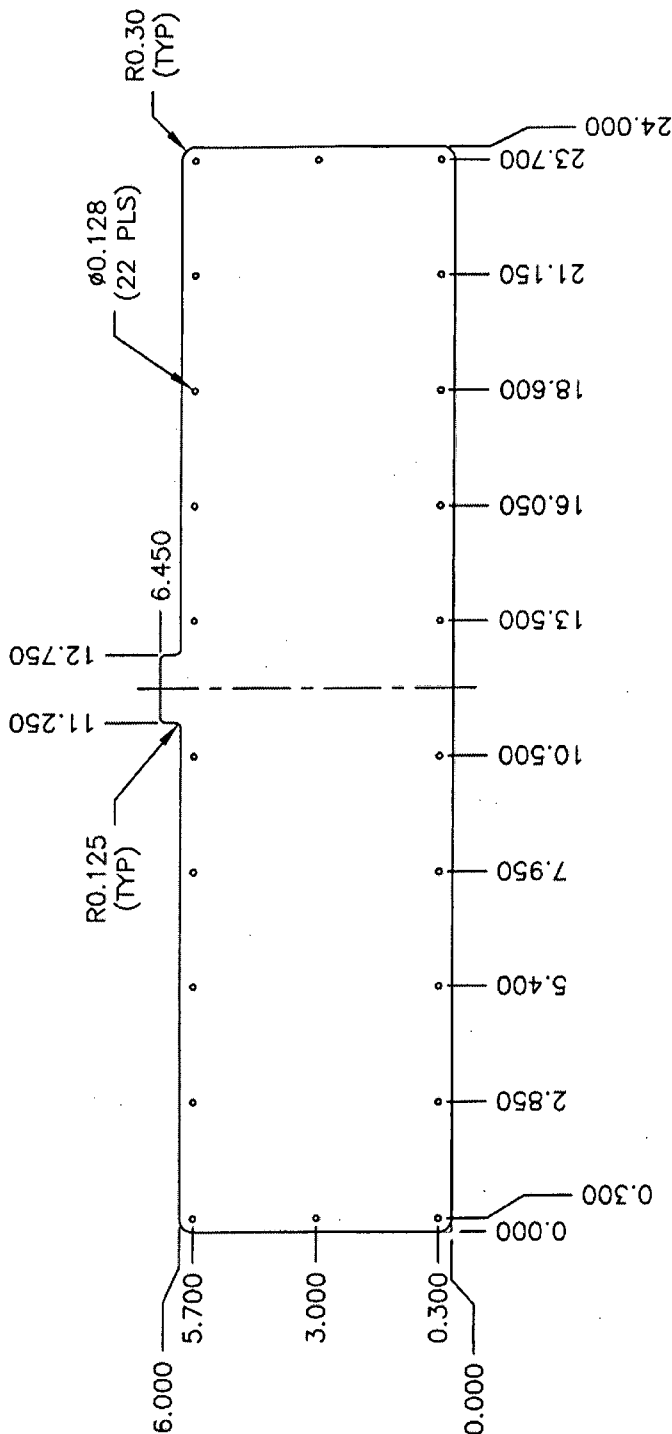
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 2 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4



D3256-1 FLAT PATTERN

D3256-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05.06.30

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DART AEROSPACE LTD		Work Order:	34608
Description: ACCESS PANEL		Part Number:	D3256-041
Inspection Dwg: D3256 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .128	+0.005 - 0.001	.129	✓			
.300	+/- .010	.300	✓			
2.850	+/- .010	2.850	✓			
5.400	+/- .010	5.420	✗			
7.950	+/- .010	7.950	✓			
10.500	+/- .010	10.500	✓			
13.500	+/- .010	13.500	✓			
16.050	+/- .010	16.050	✓			
18.600	+/- .010	18.600	✓			
21.150	+/- .010	21.150	✓			
23.700	+/- .010	23.700	✓			
24.000	+/- .010	24.000	✓			
.300	+/- .010	.300	✓			
3.000	+/- .010	3.000	✓			
5.700	+/- .010	5.700	✓			
6.000	+/- .010	6.000	✓			
11.250	+/- .010	11.250	✓			
11.750	+/- .010	11.750	✓			
6.450	+/- .010	6.450	✓			
R .30	+/- .030	R .30	✓			

Measured by: RB	Audited by: ES	Prototype Approval: N/A
Date: 07-09-18	Date: 07/09/19	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	